

## Reports Features

### Program change Log:

All changes made by the operator to the part program are recorded, and can be viewed using this built in report generator.

Useful in tracking part program changes or quality problems.

### Production Log:

The production log will track the product history of all parts ran on this machine. Including the operator name, part count and the time spent to produce the part. You can report on the product or by a selected operator.

All reports are date sensitive so the information for a specific product for a given date ranges can be displayed.

## Machine Specifications

Length	118 "
Width	52"
Height	37-1/2 "
Weight	
Electric Supply	220/440 Volt 3 Phase
Air Pressure	60 psi
Hydraulic Pressure	700 / 1000 psi
Maximum Bend Radius	10"
Maximum Bend Speed	180 degrees 1 second
Maximum Bend Angle	183 degrees
Number Bend Settings	12
Bend Accuracy	1/10 degree
Center Spindle	1"
Tooling Pilot Hole	1-3/4 "
Programmable Stops	6 to 8 Optional
Stop Travel	Optional -- Up to 24ft
Stop Accuracy	.005
Operating System	Windows 2000

### Contact:

Minland Machine, Inc.

19801 OLD 205

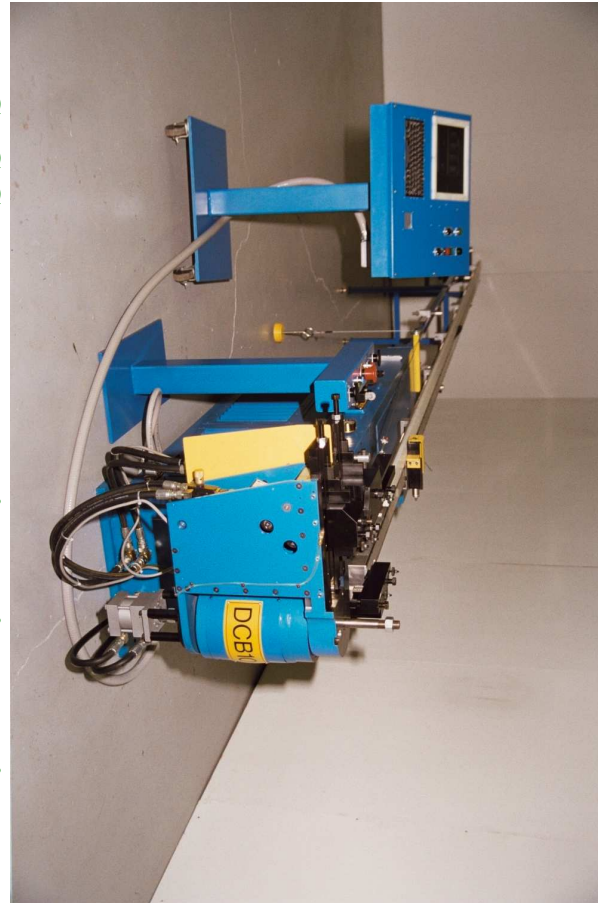
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CNC Controlled Hydraulic Bending Machine



DCB10 CNC Bending Machine

Minland Machine, Inc.  
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## Software Features:

- 1) Windows 2000 Operating system
- 2) Double safety plates on swing arm
- 3) Quick change tooling system
- 4) Split Die actuator
- 5) 12 Programmable Bend settings with adjustable Bend Speeds for each bend
- 6) Programmable Stop Settings (with Global increase/decrease)
- 7) Programmable Lube system
- 8) Load/Save/Edit Part Programs
- 9) Program notes and DXF Drawings for Operator Reference
- 10) Online machine maintenance records
- 11) Program change log and Production reports
- 12) Online help screens and operators manual
- 13) Software security system to prevent unauthorized users from making changes to part programs

## Stop Table Options:

We offer two types of CNC Stop Tables

### Multi-Stop Table - with 6 to 12 programmable stops.

Each stop is locked into position at RUN time and requires no further movement during production

#### Advantages

- 1) Faster production – no waiting for stop to move into position
- 2) Safety – The stop does not have to move during production
- 3) Wear – Less movement means less wear and longer life

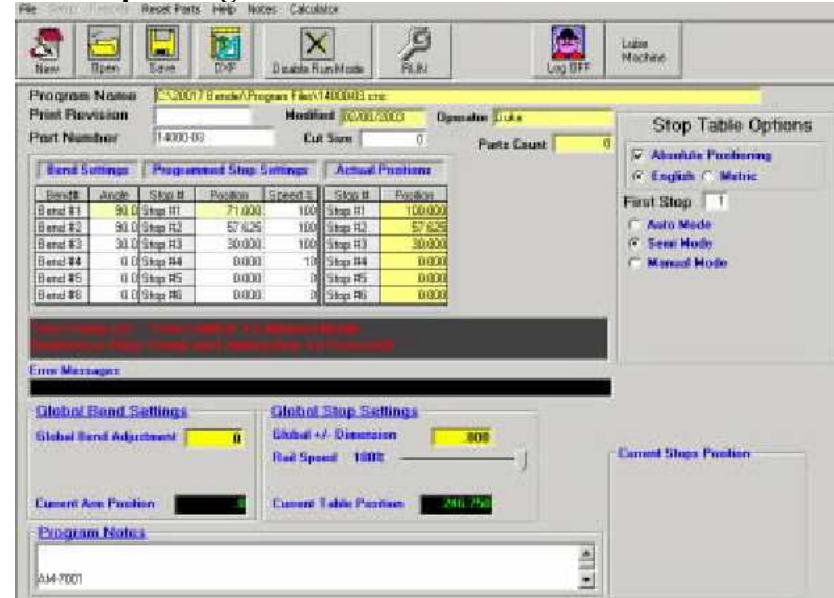
### Linear Stop Table - a single stop with infinite positioning

This stop must move into position for each bend

#### Advantages

1. Infinite positioning – closer stop settings

## Main Operating Screen



This screen is the main operating panel for the Machine. From here the operator can perform all operations necessary to program and operate the machine. With the ability to Load/Save/Create/Edit programs with a click of the mouse or by merely typing in a stop setting it makes setup a snap.

## Three operating modes

Manual (used for setup and in referencing Machine)

Semi (Clamp, Bend, Unclamp, Wait for operator to press the return button before returning home)

Automatic (Clamp, Bend, Unclamp, Return to Home)

## Advantages of CNC:

### Bend accuracy

Better bend accuracy due to hydraulic proportional Valve to control bend positioning.

### Less Scrap

By adding a CNC stop table the programs are always the same from one run to another.

### Faster Setups

By adding Quick Change Tooling System and a CNC Stop table part change over is a snap. Simply load the part program and adjust the clamp pressure then press the Run button